

Work Order ID 53216

October 27, 2009 8:02:12 AM



Page 1

Item ID:	D3826-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Rib / Gusset Assembly					
Start Date:	27/10/2009	Start Qty:	6.00	Cust Item ID:		
Required Date:	02/11/2009	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09-10-27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3826	Rev B								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- use DT9434 to assemble D2325 support gusset together 2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod								
	Batch:	1109213							
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

09/10/30
SP 09.11.05 1x

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Item ID: D3826-041
Revision ID: B
Item Name: Rib / Gusset Assembly

Accept



Setup Start



Stop



Start Date: 27/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

Base cut

0.00

Cor

SY 09/11/06

Packaging

140

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/06 SJ

UMF

09-11-06

Picklist Print

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Work Order ID: 53216

Parent Item: D3826-041RevB

Parent Item Name: Rib / Gusset Assembly


Comments:

Start Date: 27/10/2009

Required Date: 02/11/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Big Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2235-1RevB1		Manufactured	No				Each	20.0000	6.0000			
												
Basket Rib												

SAD 09-11-05

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7

51438

7

3x

Main Warehouse

WA

13

50565

3

51871

10

3x

SY 09/10/29

D3929-041RevA

Manufactured

No



Gusset Assembly

Each

17.0000

6.0000

SAD 09-11-05

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

47273

1

51439

6

52831

10

6x

SY 09/10/29

Picklist Print

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Work Order ID: 53216



Parent Item: D3826-041RevB



Parent Item Name: Rib / Gusset Assembly

Start Date: 27/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3929-042RevA		Manufactured	No				Each	16.0000	6.0000			
Gusset Assembly												



SAP

09-11-25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

50567

2

50869

1

51137

3

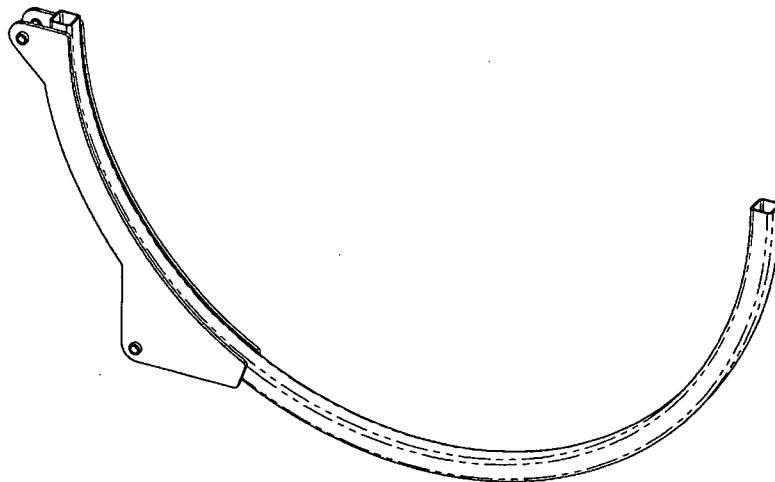
52835

10

* Not Entered => B53343 -> ①

5x

SY 09/10/29



D3826-041 RIB/GUSSET ASSY

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△ B

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WITHOUT NOTICE
WORK ORDER
NO. 53214

B/ 09-10-27

RELEASED
8/14/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.32 lbs

△ B

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	D3826	SHEET 1 OF 2
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	RIB/GUSSET ASSY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

△ D3929-042
GUSSET ASSEMBLY

△ D3929-041
GUSSET ASSEMBLY

0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

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WORK ORDER
NO. 53216

RELEASED
2/24/12

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3826	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB/GUSSET ASSY	NTS
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